Work Order January-08-14 12:				*110	1972*			Y (Page 1
Revision ID:	3574-6 abin Floor Protector			Accept	*N900	040	100)* s	Setup Sta	171	S1* S2*
Start Date: 1/0 Required Date: 1/0 Reference:	08/14 Start Qt 08/14 Req'd Q		*1* *1*		Cust Item l Customer:	D:				14	. 12
	Process Plan:	PIMLZ	Date: <u>\4-01- C</u>	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	^Ι \ Ι φ	R1* R2*
Sequence ID/ Work Center ID	Operatio Descripti			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3574	Revision Nbr										
100	FLOW WA	TER JET		0.00				1	٥		Jm14-02
Waterjet FLOW CNC Waterjet		Memo 1-Cut as per D Dwg Rev: Prog Rev: 2-Deburr	wg D3574 B	0.00				•			<u></u>

1 0 Jm14-02-3

0.00

0.00

110

*11**0***

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

DQA:			Date:			- ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~									
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE					AEROSPACE
QA Closed:			Date:							<u> </u>	Nork	Order up	date only		
Work Orde	r:					DISPOSITION	Ì			AGAINST [DEPA	RTMENT	PROCESS		
	•				_	Rework			Skid-tube	Crosstube			Water Jet	7	Engineering
Part N	lo.					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.	┨	Quality
	•				_	Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging]	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite [Supplier	_]	
Root					Desci	ription of work order update		nitial	Acti	on .		Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification		QC Inspector
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material														1	
Operator						ļ									
Offset/Setup															
Process	_														
Supplier	_	:													
Training												•			
Transport							1				1			1	
Unapproved					<u> </u>				TECODY		. L_				
				,			FA	ULI CA	TEGORY						
Landii	ng C	Bending				General Bend		احمانه را	Program	Г	\neg	utside Dim	onsions [٦,	Pressure/Forced
		Centre No	at Cancar	atric	-	BOM/Route	-	Grain	riograffi	-		ver/Under	<u></u>	_	Set-up
		Cracks	ot concer	ittic	-	Broken/Damage/Defect	-	Hardwa	are	•	-	art Incorrec		_	Temperature/Cure
		Crimp/Kir	nk/Rinnle	/\Mayo	\vdash	Burrs	-	-	ion Incomplete/Un	gualified		art licorrec	├	_	Weld
		Cuffs	IIV MPPIE	, wave	 	Contamination	\vdash	┪ :	tions Incomplete/U	·		art Moved	-	-	Wrong Stock Pulled
		Crushing				Countersink	\vdash	4	gned/off center	. roicui		ositioned V	L Vrong	┙	one ocook i uneu
		Heat Trea			-	Cut Too Short	-	Mislab	_	<u> </u>	_	ower Loss/		\neg	Other
		Inspectio		Tube		Drawing		Misrea		L	—J¨``	2007			
·	-	Marks/Ch	•			Drill Holes		Off-set			_				
		Turning S				Finish		4	Calibration					-	
		Wave/Tw	•			Fit/Function		-{	Sequence		_				

Work	Order ID	110972

110972

Page 2

January-08-14 12:44:33 PM Accept **Item ID:** D3574-6 *N900040100* Setup Start **Revision ID:** Cabin Floor Protector **Item Name:** *1* **Start Qty:** 1.00 **Start Date:** 1/08/14 **Cust Item ID:** Required Date: 1/08/14 Req'd Oty: 1.00 *1* **Customer:** Reference: Start Run Date: _____ **Tooling:** Process Plan: **Approvals:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Reject Set Up/ Tool ID Reject Tool # Plan Accept Insp. Work Center ID **Description** Code Qty Number Stamp **Run Hours** Qty DAS 0.00 120 QC8- Inspect parts - second check *120* OC Memo Quality Control 130 0.00 Small Fab *120* 0.00 Small Fab Memo Deburr if necessary. Small Fab QC5- Inspect part completeness to step on W/O 140 *140* QC 0.00 Memo Quality Control

DQA:			Date:										
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAI	NST DE	PARTMENT	PROCESS	
	•				_	Rework			Skid-tube Crosstu	ıbe	1	Water Jet	Engineering
Part N	10.					Scrap			Machining Small	Fab	Pro	d. Eng. Coor.	Quality
	•			٠	_	Use-as-is		Therr	noforming Finish	ing	Rec/Stor	e/Packaging	Other
NCR N	10.		• • • • • • • • • • • • • • • • • • • •			Suspected Unapproved			Large Fab Compos	site]	Supplier	
Root					Desci	ription of work order update	Ī	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup			ŀ										
Process													
Supplier							1						
Training													
Transport Unapproved													
опарргочец			1	l	<u> </u>		FΔI	JIT CA	TEGORY		I		1
Landi	ng G	Gear				General							
		Bending			Г	Bend		Folio/I	Program		Outside Dim	ensions	Pressure/Forced
!		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	_	Cuffs	• • •			Contamination	\vdash	1 .	tions Incomplete/Unclear		Part Moved	_	Wrong Stock Pulled
	_	Crushing				Countersink	-	4	gned/off center		Positioned V	Vrong	-
		Heat Trea	it			Cut Too Short	-	Mislab	-		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d	-			
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
			Fit/Function		Out of	Sequence							

Wo	rk ()rder	ID	110972
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110972

Page 3

January-08-14 12:44:33 PM D3574-6 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Cabin Floor Protector **Start Oty:** 1.00 *1* **Start Date:** 1/08/14 **Cust Item ID:** Required Date: 1/08/14 **Req'd Qty:** 1.00 *1* **Customer:** Reference: Start Run Process Plan: _____ Date: **Tooling: Approvals:** Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 150 Identify as per dwg & Stock Location: 0.00 DAS *150* Packaging 0.00 Memo **Packaging** 160 QC21- Final Inspection - Work Order Release 0.00 MLJ 14-02-03 *160* QC 0.00 Memo Quality Control

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE				AEROSPACE
QA Closed:			Date:							V	Vork Orde	r updat	te only	
Work Orde	r:					DISPOSITION				AGAINST D	EPARTME	NT/PR	OCESS	
	•				_	Rework			Skid-tube	Crosstube		١	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	┪		ng. Coor.	Quality
	•				_	Use-as-is			noforming	Finishing			Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite	1	•	Supplier	1
	•								- 1	· •				
Root					Desci	ription of work order update	l	nitial	Acti	on	Sign 8	k		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	· \	/erification	QC Inspector
Design														
Doc/Data														
Equip/Tooling				,										
Handling/Pre														
Material														
Operator			<u> </u>											
Offset/Setup														
Process											1	ŀ		
Supplier												İ		
Training							١							
Transport			1											
Unapproved	L.										<u> </u>			<u>, </u>
							FA	ULT CA	TEGORY					
Landi	_	1				General	_	1		_	_		_	<u> </u>
	-	Bending			_	Bend		1	Program	-	Outside		<u>-</u>	Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route		Grain		 -	Over/Ur		erance	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Inco		_	Temperature/Cure
		Crimp/Kir	nk/Ripple,	/Wave		Burrs	<u> </u>	1 '	ion Incomplete/Un	·	Part Los		lg -	Weld
		Cuffs			_	Contamination		4	tions Incomplete/U	nclear	Part Mo			Wrong Stock Pulled
	-	Crushing			<u> </u>	Countersink	\vdash	1	gned/off center	_	Position			-
	<u> </u>	Heat Trea			 	Cut Too Short	_	Mislabe		Ĺ	Power L	oss/Sur	ge	Other
	<u> </u>	Inspectio		Tube		Drawing	L	Misrea					·	
	<u> </u>	Marks/Ch		٠		Drill Holes	<u>_</u>	Off-set						<u> </u>
	<u> </u>	Turning S				Finish		4	Calibration				·	
	Wave/Twist in Tube Fit/Function		Fit/Function	L	Out of	Sequence								

January-08-14 12:44:33 PM

Work Order ID:

110972

Parent Item:

D3574-6

Parent Item Name:

Cabin Floor Protector

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07.07.23 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	НЕЕТ	Purchased	No				sf	1,461.9900		26)		Jni	U-UZ.
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT019		1461.99							
				1248	366	906							

555.99

127939

m126425

DQA:			Date: _										TQ AC	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE			AEROSPACE	
QA Closed:			Date:							V	ork Order up	date only		
Work Orde	r·					DISPOSITION				AGAINST D	DEPARTMENT/PROCESS			
Work Oraci	•					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering	
Part No	ο.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	-			· · · · · · · · · · · · · · · · · · ·		Use-as-is			noforming	Finishing		re/Packaging	Other	
NCR N	o.					Suspected Unapproved			Large Fab	Composite		Supplier	1 1	
	_													
Root					Desci	ription of work order update	1	nitial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector	
Design	\Box		İ											
Doc/Data							Į							
Equip/Tooling														
Handling/Pre	_													
Material	_										'			
Operator	4										:			
Offset/Setup	_						ł							
Process	_													
Supplier	\dashv													
Training	_													
Transport	_													
Unapproved	i													
1 49							FA	ULI CA	TEGORY					
Landin F	_					General	$\overline{}$]:_ <i>/</i> :		Г	Outside Dim	:	7,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
	ᅰ	Bending Centre No	at Camaan		-	Bend BOM/Route	\vdash	Grain	Program	-	Over/Under	<u> </u>	Pressure/Forced Set-up	
	ᅱ	Cracks	ot Concen	itric	-	Broken/Damage/Defect	\vdash	Hardwa	1 0	-	Part Incorre		Temperature/Cure	
-	\dashv	Cracks Crimp/Kir	k/Pinnla	Mayo	\vdash	Burrs	-	4	ire ion Incomplete/Un	auglified –	Part Lost/Mi	<u> </u>	Weld	
		Cuffs	ik/ kipbie/	vvave	-	Contamination	\vdash	4 '	tions Incomplete/U	· –	Part Moved	221118	Wrong Stock Pulled	
		Crushing	•		-	Countersink		4	gned/off center	L	Positioned V	Vrong L		
		Heat Trea	nt			Cut Too Short	\vdash	Mislab		-	Power Loss/	_	Other	
-		Inspection		Tube		Drawing	\vdash	Misrea		L	الــــــــــــــــــــــــــــــــــــ		10 the	
<u> </u>	_	Marks/Ch	•			Drill Holes	<u> </u>	Off-set						
		Turning S				Finish	\vdash	4	Calibration			<u>, </u>		
		Wave/Tw		e		Fit/Function		4	Sequence		-			

DART AEROSPACE LTD	Work Order:	110972
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	lolerance	Dimension	Accept	110,001	Inspection	
Ø3.00	+0.006/-0.001	3.004	_		V	Jemoi
7.37	+/-0.030	7.37	-		V	
11.00	+/-0.030	11.00	_		T	
15.25	+/-0.030	15,25"			<u> </u>	
25.87	+/-0.030	25.87"	_		T	
39.75	+/-0.030	39.75"	_		丁	
44.75	+/-0.030	44.754	_		T	
58.38	+/-0.030	56.38°	•		Ť	
63.50	+/-0.030	63.50	_			
65.25	+/-0.030	65.25			T	
10.25	+/-0.030	10.25	_		V	
11.87	+/-0.030	11.87	-		ν	
14.75	+/-0.030	14.75			T	
26.00	+/-0.030	26,000	_		4	
40.87	+/-0.030	40.87"	J		T	
45.00	+/-0.030	45,00			4	
48.00	+/-0.030	48.00			<u> </u>	
55.13	+/-0.030	55.13"			<u> </u>	
61.25	+/-0.030	61125	_			
61.88	+/-0.030	61.88	-		Т	
64.63	+/-0.030	64.63			<u> </u>	
1.13	+/-0.030	1,13"	_		V	
7.63	+/-0.030	7.63			V	
11.00	+/-0.030	11.00,			1	
22.10	+/-0.030	22.10	_		7	
22.50	+/-0.030	27.00			1	
24.50	+/-0.030	24.50			T	
35.13	+/-0.030	35,13"	_		丁	
36.50	+/-0.030	36.50"	_		1	
40.00	+/-0.030	40,00			丁	
41.88	+/-0.030	41.88			丁	
43.63	+/-0.030	43.63"	-		1	
6.75	+/-0.030	6.75"			ν	
9.50	+/-0.030	9.50"	-		V	

DART AEROSPACE LTD	Work Order:	110972
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10,38"			T	
14.50	+/-0.030	14.50			T	
16.75	+/-0.030	16.75	_		T	
18.94	+/-0.030	18.94			7	
19.00	+/-0.030	19.00"				· · ·
24.13	+/-0.030	24.13"	_		5	
33.88	+/-0.030	33.891	_		丁	
39.50	+/-0.030	39.50			T	
40.25	+/-0.030	3/0.50	-		T	
43.50	+/-0.030	43.50"			T	
46.60	+/-0.030	46.60	_		丁	
0.125	+/-0.010	0.125			✓	

		DAS		
Measured by:	Audited by	27	Prototype Approval:	N/A
Date: 14-07	2-3 Date		Date:	N/A

Rev	Date	Change	Revised by	Approved=
Α	08.01.16	New Issue	KJ//DD	
В	09.05.15	Dimensions updated per Dwg Rev B	KJ 95	

30.75 11.50 8 19.00 REF 7.37 10.75 10.75 0 11.00 11.00 15.25 14.75 25.50 25.87 25.75 R1.50 26.00 2 PL 32.87 R200.0 -38.81 39.75 44.75 44.75 45.00 \bigoplus B 1.75 49.11 51.11 48.25 53.51 Ø3.00 110972 MP TYP 58.38 61.25 14-01-10 63.50 64.13 64.63 65.25 0.125 66.50 REF R0.25 TYP 26.50 24.13 **D3574-1 CABIN FLOOR PROTECTOR** NEW ISSUE Α REV. DESCRIPTION NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) DESIGN 2) FINISH: N/A

ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5: -2 NOW SHOWN ON SHEET 2 09.03.25 СВ 07,06,08 DATE DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3574 MFG. APPR. SHEET 1 OF 6 APPROVED TITLE SCALE CABIN FLOOR PROTECTOR DE APPR. NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD

HT IS PRIVATE AND COMPREHING, MICH SUPPLED ON THE EXPRESS CONSTRUCT THAT IT IS
SEED FOR MAY PLANDED OR COMMUNICATION TO MAY CITIES A RESIDENT WITHOUT DATE 09.03.25

3

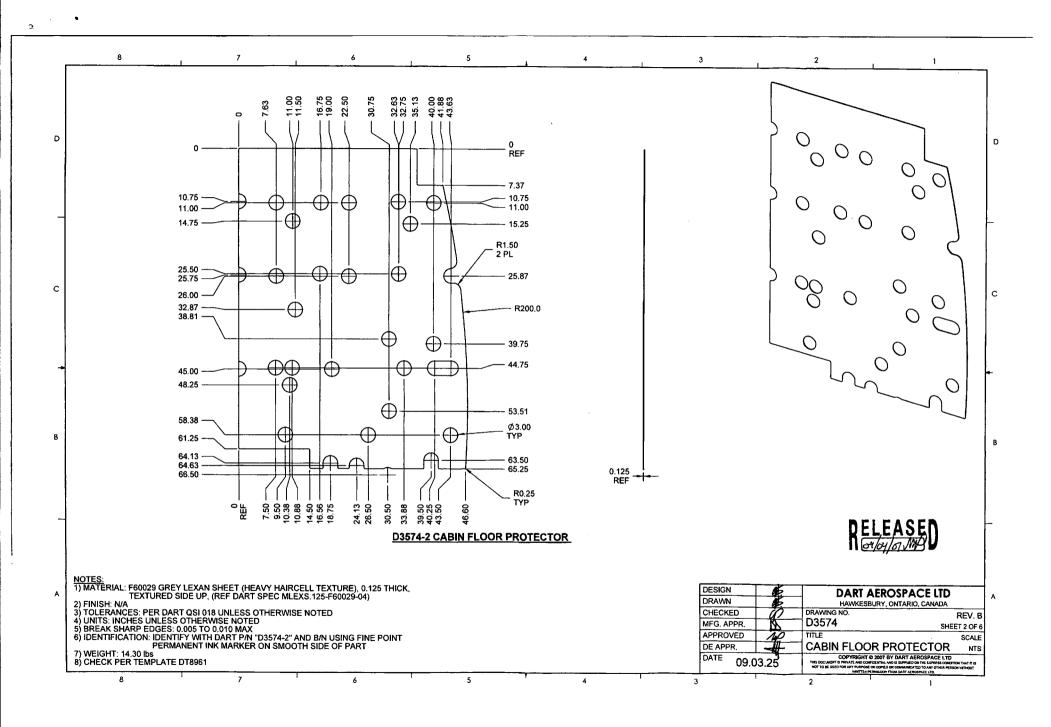
3

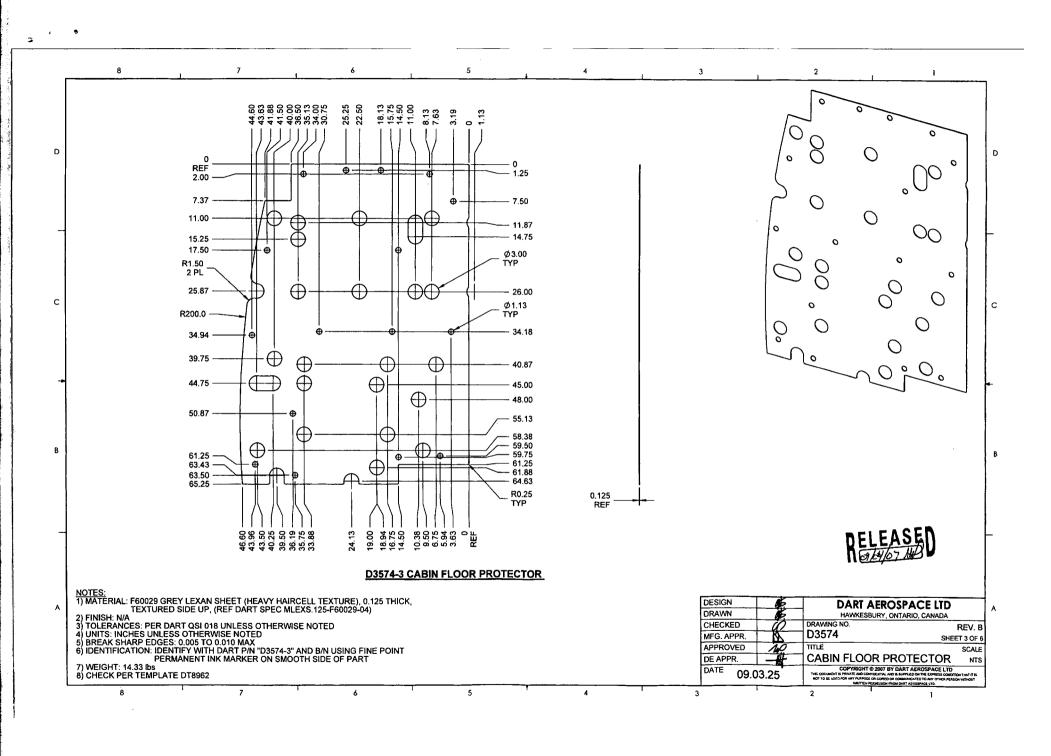
D

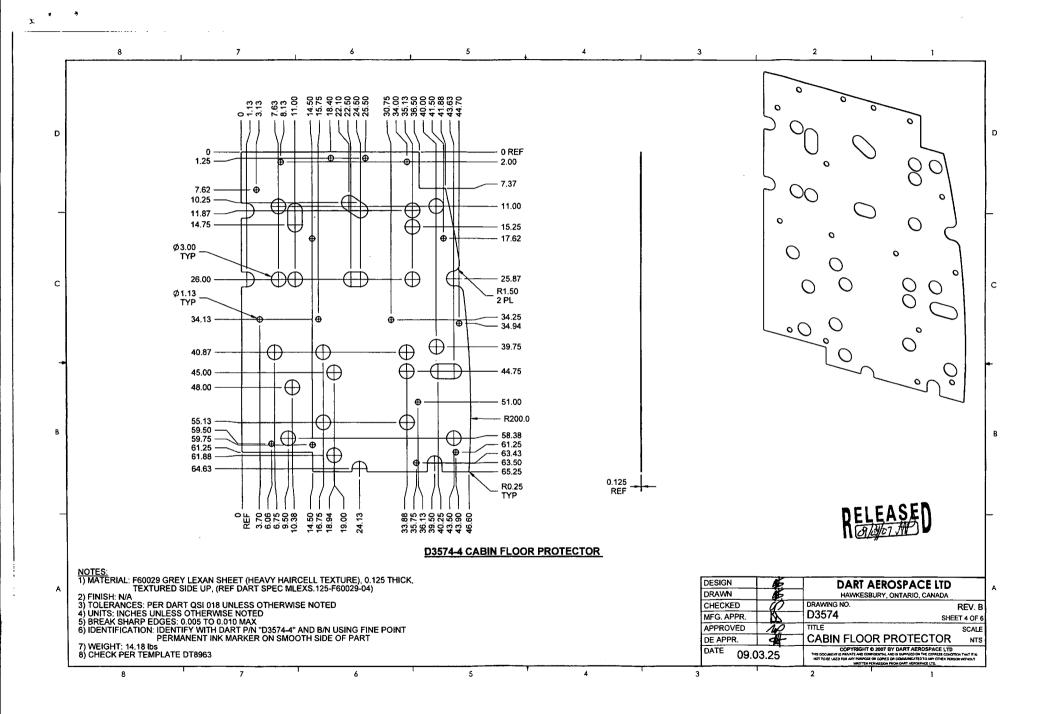
8) CHECK PER TEMPLATE DT8961

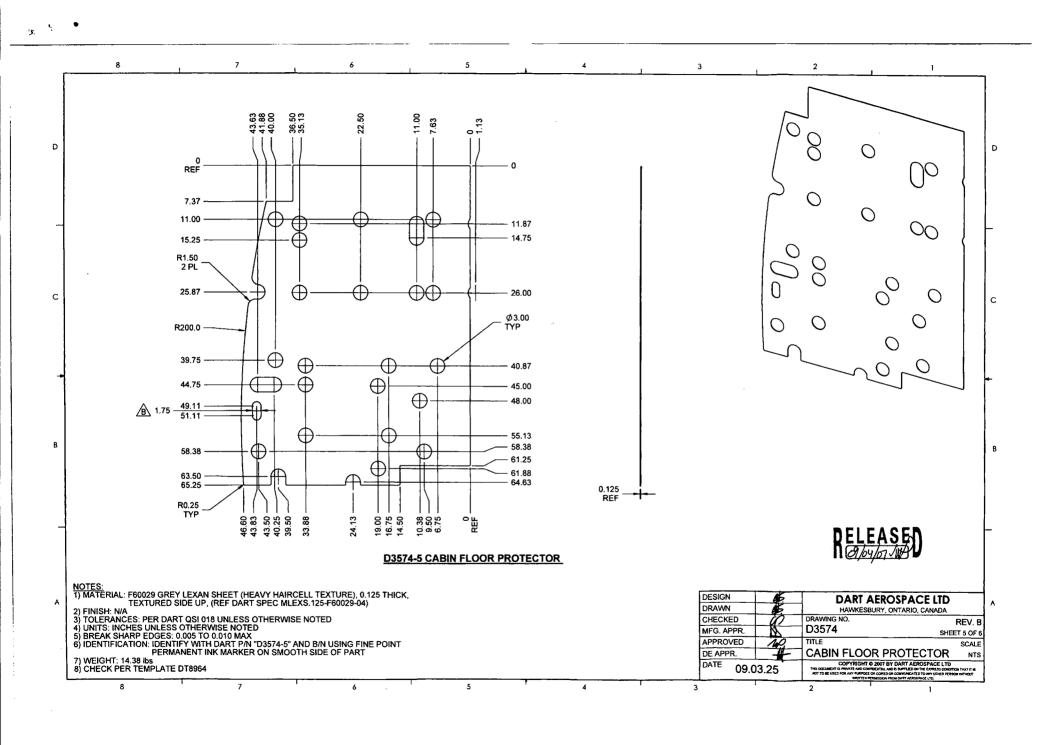
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART









22.10 22.50 24.50 35.13 36.50 40.00 41.88 43.63 11.00 7.63 ŘEF 7.37 10.25 - 11.00 11.87 14.75 15.25 26.00 25.87 R1.50 2 PL Ø3.00 TYP \oplus 39.75 40.87 44.75 45.00 --48.00 -- R200.0 55.13 58.38 61.25 61.88 63.50 64.63 65.25 0.125 R0.25 REF TYP 39.50 -40.25 -43.50 -6.75 9.50 10.38 14.50 16.75 18.94 19.00 24.13 **D3574-6 CABIN FLOOR PROTECTOR** NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) DESIGN DART AEROSPACE LTD 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3574 MFG. APPR. SHEET 6 OF 6 APPROVED TITLE SCALE DE APPR. CABIN FLOOR PROTECTOR 7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965 COPYRIGHT © 2007 BY DART AEROSPACE LTD
OF STRINKT, AND COMPOSITION OF COMPUTED ON THE LEMELSS CONCINCTION
OF THE LEMELS OF COMPUTED ON THE LEMELS FEELD WITH
WAITER PERSONNEL OF COMPUTED ON THE LEMELS FEELD WITH DATE 09.03.25